

Work Order ID 48669A

July 2, 2009 8:39:54 AM

Page 1

Item ID: D2221

Accept

Revision ID: H

Item Name: 350 Basket Base

Setup Start

Stop

Start Date: 7/15/09 Start Qty: 1.00

Required Date: 8/03/09 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221 A/R ER316 S.S.
Rod Batch: 4109213

SY 09/07/07

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

Cpl 0907.07

0907.07

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

=> 809/07/07 @

Work Order ID 48669A

July 2, 2009 8:39:54 AM



Page 2

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 7/15/09 Start Qty: 1.00



Cust Item ID:

Required Date: 8/03/09 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

1- Plug holes prior to 10:30am 2- 1ST COAT: START

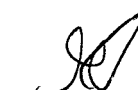
TIME: 10:40am OVEN TEMPERATURE:

11:00am FINISH TIME:

11:30am ***** 2nd coat if 11:30am 11/11/422

necessary***** 2ND COAT: START

09-07-08



140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

09-07-8

BK

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/09

U 9.07.09

Picklist Print

July 2, 2009 8:39:53 AM

Work Order ID: 48669A

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Comments:

Start Date: 7/15/09

Required Date: 8/03/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3826-041RevB		Manufactured	No			100	Each	6.0000	2.0000 ✓			
												
Rib / Gusset Assembly												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	6	
48644	6	

Date: Friday, 19/06/2009 11:22:41 AM
 User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BASKET BASE ASSEMBLY (350)
 Job Number : 48669A
 Estimate Number : 10189
 P.O. Number :
 This Issue : 19/06/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D2221
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D2221 REV H
 Previous Run : 48667A Project Number : N/A
 Material :
 Due Date : 26/06/2009 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : MF 09-06-19
 Comment : Est Rev:J 05-09-02 Added D3442-1 KJJ/JLM
 Est Rev:K 08-08-29 revG as per dwg DD verified by:EC
 Est Rev:L 08-09-24 plug holes prior to powder coat DD
 verified by:EC
 Est Rev:M 08-12-02 revH as per dwg DD verified by:

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
✓ 1.0	D22211	Rib
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B48318</u>	
		<u>SAN 09-06-19</u> <u>AD 09</u>
✓ 2.0	D22215	Rib
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib batch: <u>B48390</u>	
		<u>SAN 09-06-19</u>
✓ 3.0	D22217	Pib
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B48201</u>	
		<u>SAN 09-06-19</u>
✓ 4.0	D22323	Basket Hinge
	Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Basket Hinge batch: <u>B47263</u>	
		<u>SAN 09-06-19</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 19/06/2009 11:22:41 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)















Job Number: 48669A

Part Number: D2221

Job Number:



Seq. #:	Machine Or Operation:	Description :
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✓ 5.0	D22351	Basket Rib	 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Basket Rib batch: <u>B48451</u> <i>SAD 09-06-19</i>			
✓ 6.0	D2581	Mounting Bracket	 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Mounting Bracket batch: <u>B48428</u> <i>SAD 09-06-19</i>			
✓ 7.0	D34421	Shim	 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Shim batch: <u>B47074</u> <i>SAD 09-06-19</i>			
✓ 8.0	D3825041	Rib Assembly (Basket End)	 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib Assembly (Basket End) batch: <u>B48430</u> <i>SAD 09-06-19</i>			
✓ 9.0	D3826041	Rib / Gusset Assembly	 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib / Gusset Assembly batch: <u>B48644</u> <i>PD 09-06-23</i>			
✓ 10.0	D3827041	Rib Assembly (Inboard)	 
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib Assembly (Inboard) batch: <u>B48100</u> <i>SAD 09-06-19</i>			
✓ 11.0	D38331	Mesh (Base End Face)	 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Mesh (Base End Face) batch: <u>B48322</u> <u>48217</u> <i>SAD 09-06-19</i>			

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 48669A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D38321

Mesh (Base)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Mesh (Base)

batch: B48332

SAD 09-06-19 ①

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M108160

09/07/07

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

09-07-07

AD

15.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

09/07/07

09/07/07

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

M111472

1- Plug holes prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

10:30AM

OVEN TEMPERATURE:

400°F

FINISH TIME:

11:00AM

***** 2nd coat if necessary *****

2ND COAT:

START TIME:

11:00AM

OVEN TEMPERATURE:

400°F

FINISH TIME:

11:30AM

09-07-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 19/06/2009 11:22:41 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 48669A

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-07-8 @

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

✓

Job Completion



✓

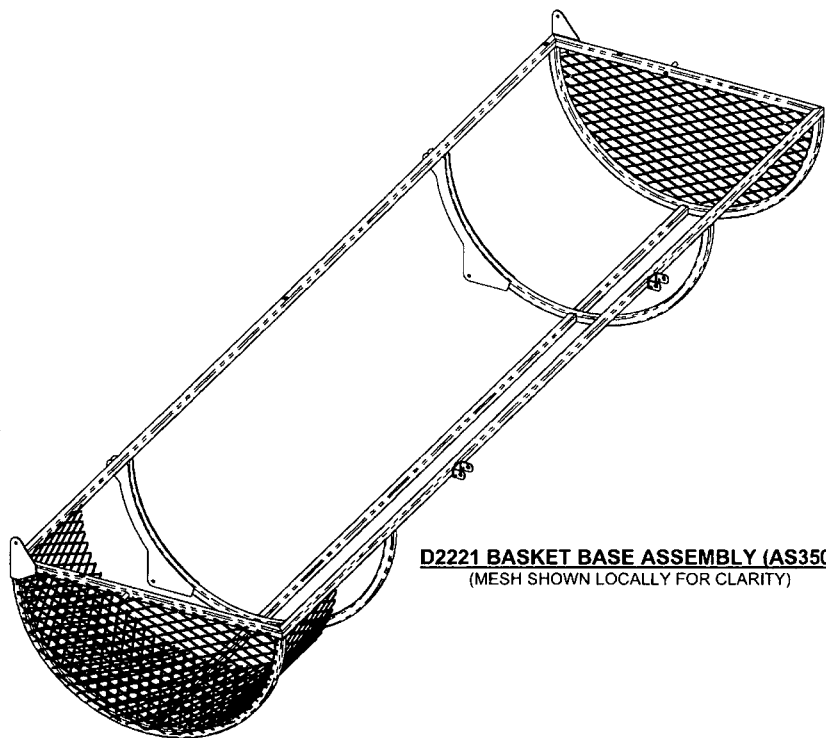
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

#48669A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN D6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2227-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	B		
CHECKED	JSS	DRAWING NO.	REV. H
MFG. APPR.	THP	D2221	SHEET 1 OF 5
APPROVED	THP	TITLE	SCALE
DE APPR.	THP	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

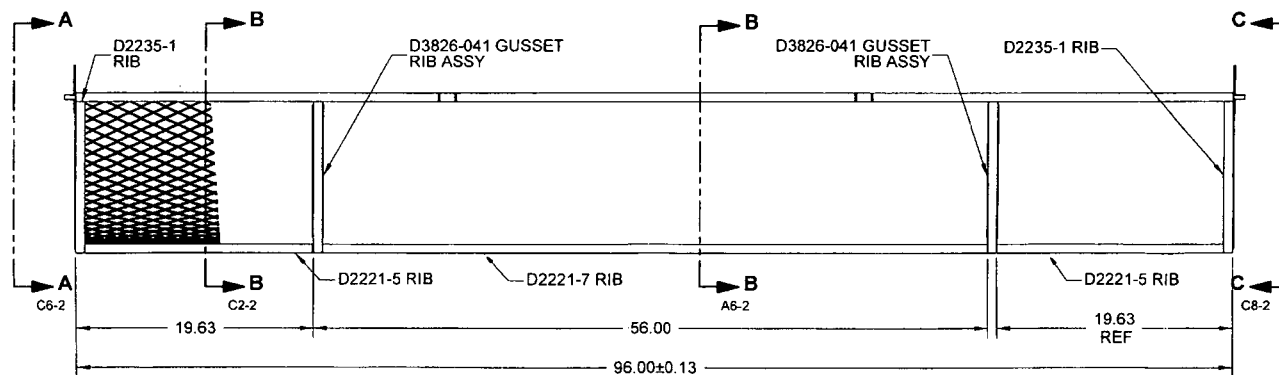
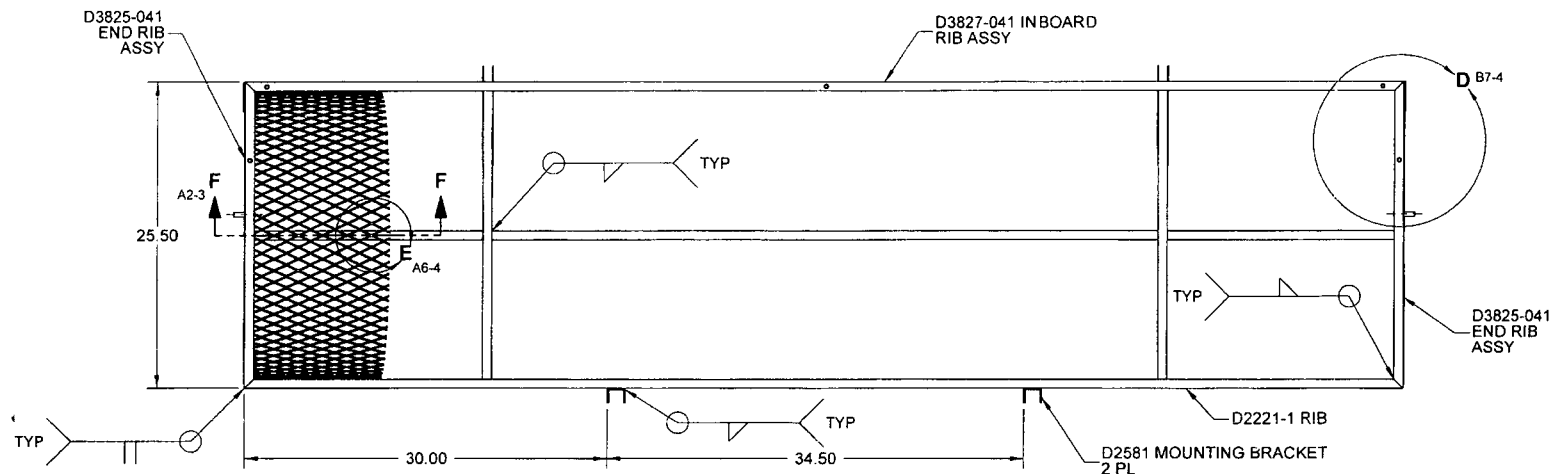
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

4866 9A

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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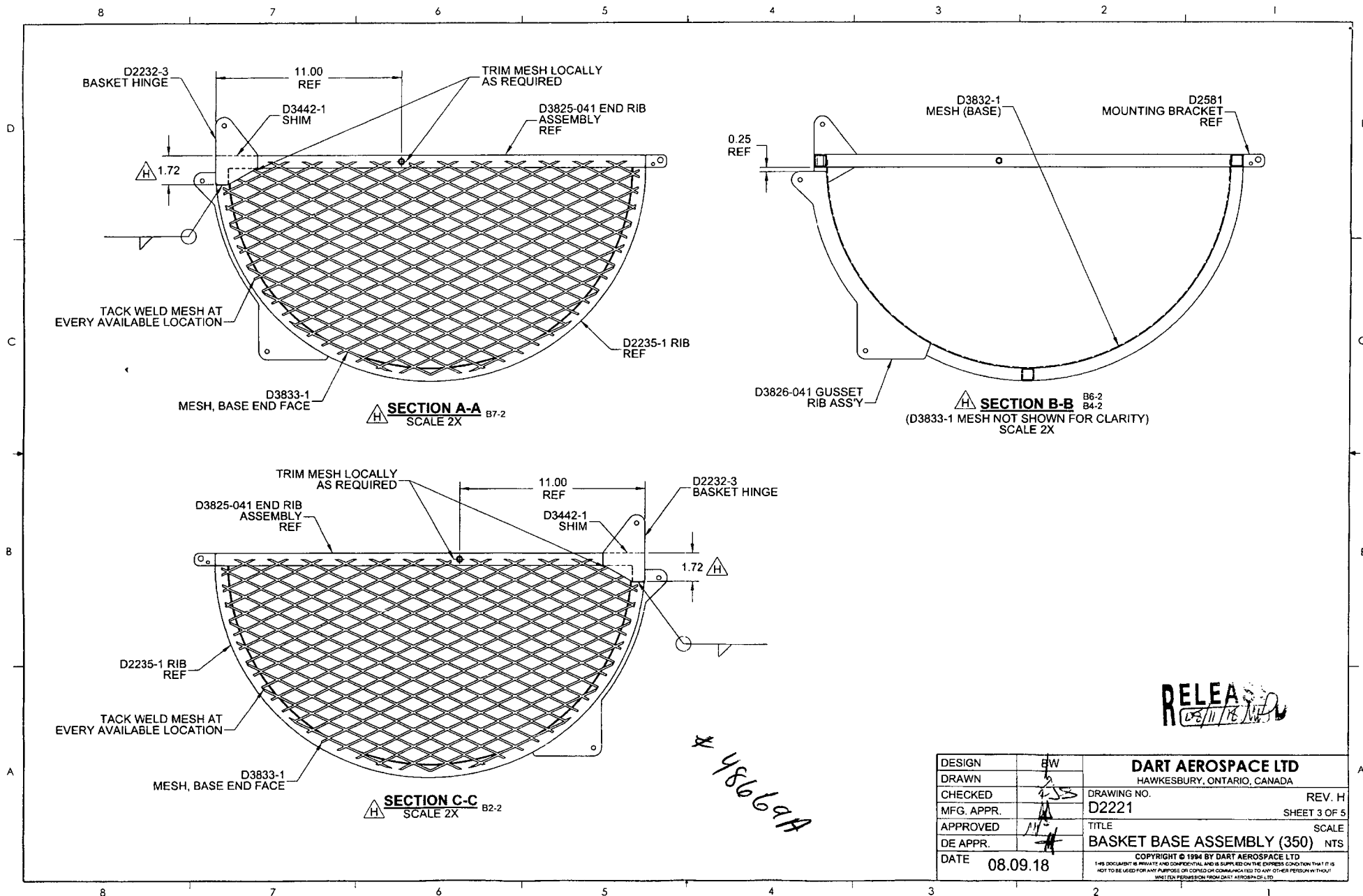
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASE
08/11/18

DESIGN	HW	DART AEROSPACE LTD	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4-SS	DRAWING NO. D2221	REV. H
MFG. APPR.	1/1	SHEET 3 OF 5	
APPROVED	1/1	TITLE	SCALE
DE APPR.	1/1	BASKET BASE ASSEMBLY (350)	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

C

B

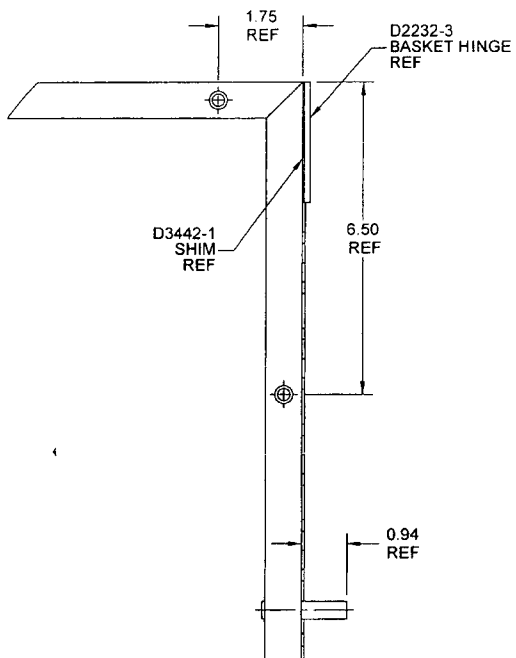
A

D

C

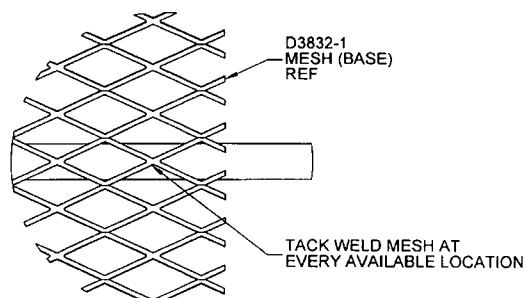
B

A

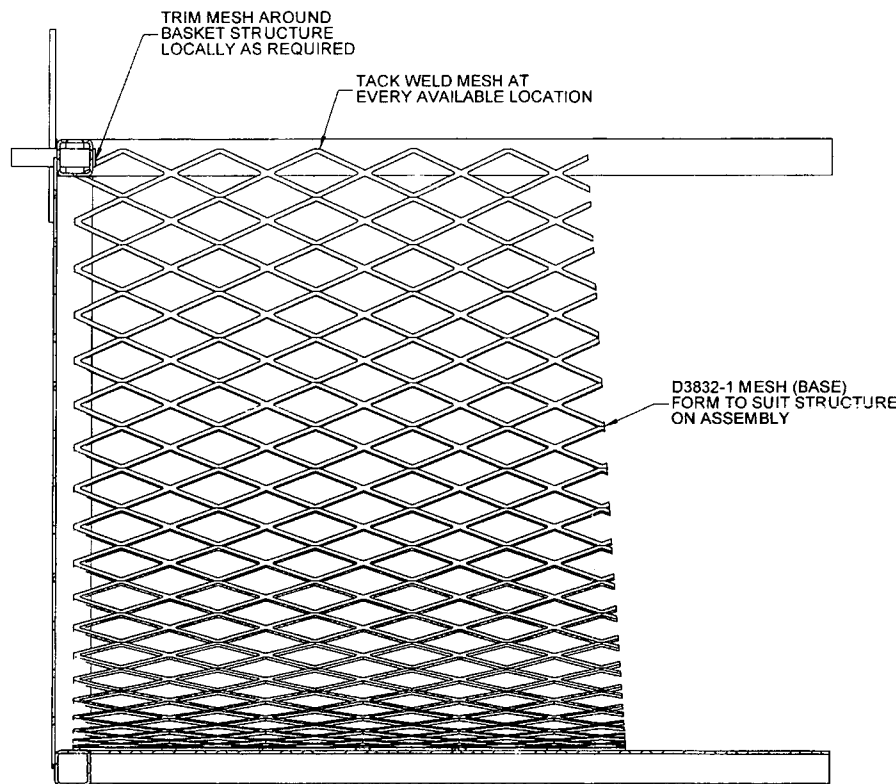


DETAIL D
SCALE 4X D2-2

#48669A



DETAIL E
SCALE 4X C6-2



SECTION F-F
SCALE 4X D7-2

RELEASED
08/11/16

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	14/3	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED	14/3	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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8 7 6 5 4 3 2 1

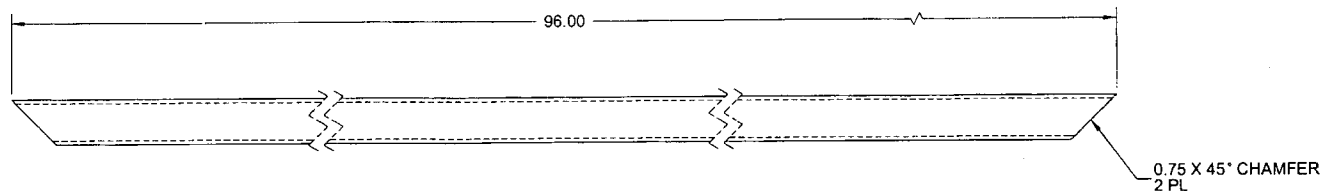
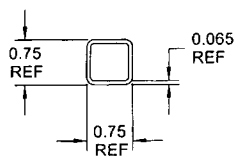
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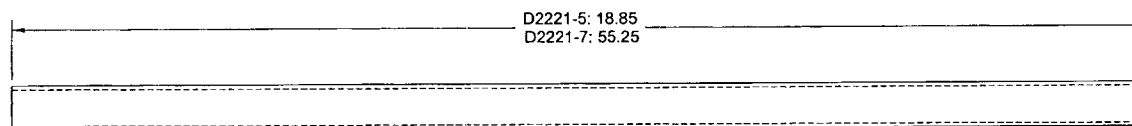
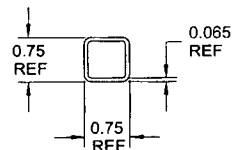
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NOTE: Date & initial all entries



D2221-1 RIB



D2221-5/-7 RIB

48669A

RELEASED
06/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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